

Date: 6/23/2006 7:34AM
User: Kim Johnston

PROCESS SHEET

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job No.	: 27667	Part No.	: D31121
Estimate No.	: 10367	Drawing No.	: D3112 REV B
P.O. No.	: N/A	Drawing Rev.	: B
SO No.	: N/A	Project No.	: N/A
First Issue	: N/A	Material	: N/A
Prsht Rev.	: NC	Due Date	: 6/29/2006
This Issue	: 6/23/2006	QTY:	: 8
Prev. Run	: 27365	Type	: MACHINED PARTS

Written by:

Checked & Approved by:

Comment :

Est. A 02.05.22 New Issue NG

Job Number:



Seq. No.	Machine or Operation	Description
1.0	M6061T6B0625X01500	6061-T6 Bar .625" x 1.5"
	Comment: Qty.: 0.2385 f(s)/Unit Total : 1.9076 f(s) 6061-T6 Bar .625 X 1.500" Material: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8) Bar ref DART spec M6061T6B Batch M14037	
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blanks: 0.625" x 1.500 bar x 2.625" long.	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA233 Note: Engrave / scribe DART P/N on part as per dwg. Deburr break all unmarked sharp edges .005 to 0.010	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DS Date: 06/07/06

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Number:



Seq. No.	Machine or Operation	Description
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	DL 06/07/05 (8)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	FL 06 07 05 (8)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: 57408	12/4/15 (8)
10.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	06/07/06 (8) u 06 07 05

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

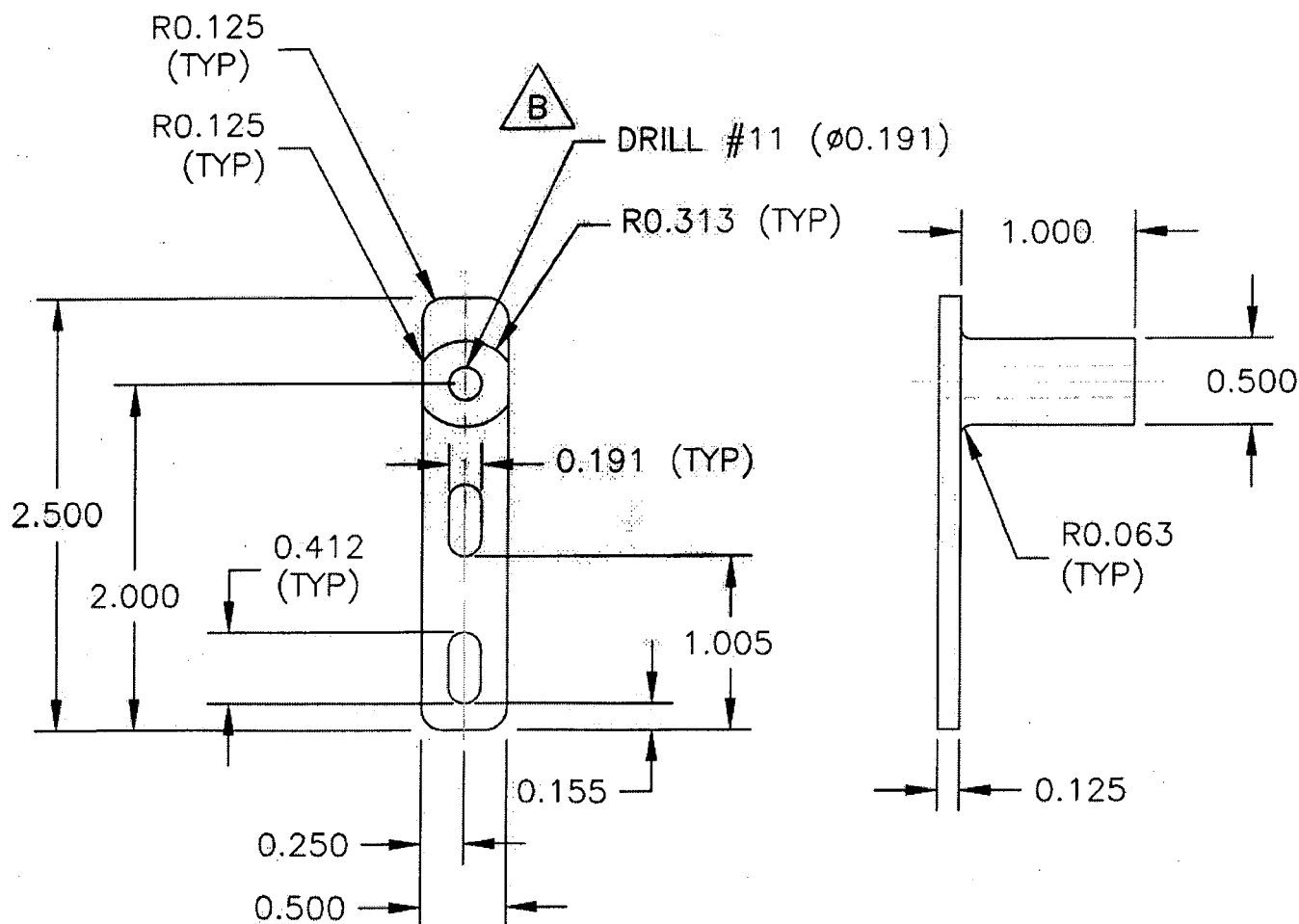
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3112	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE GUIDE	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; Ø0.191 WAS Ø0.185	

RELEASED
04.11.23



D3112-1 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)
BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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